

SOLD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4149-3

Job Sheet 172545



Part No: D4149-3

Job Qty: 20 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/2/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD IPP Rev:B 11.03.03 as per revC DD
verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	3/1/18	3/1/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	20 pcs	3/1/18	3/1/18	0.00	0.06	Bandsaw1		
110	CNC Vertical Machining	20 pcs	3/2/18	3/2/18	0.12	8.73	HAAS1-4		
130	QC	20 pcs	3/2/18	3/2/18	0.00	0.00	QC8 Machining-2		
170	Packaging	20 pcs	3/2/18	3/2/18	0.00	0.00	Packaging3-2		
180	QC21-SA	20 Ea	3/2/18	3/2/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.000X1.000	M303B1.000 X 1.000	6.6667 ft (.33333333 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303B1.000X1.000	7	7	0

DART
AEROSPACE

Hawkesbury, ON K6A 1K7
CANADA
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Container No: S056159



Part: D4149-3

Job No: 172545

Serial No/Batch: S056159

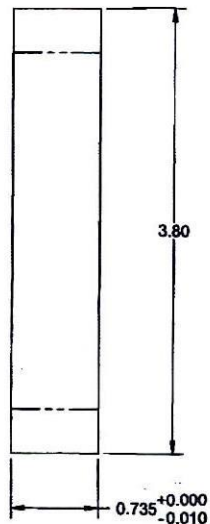
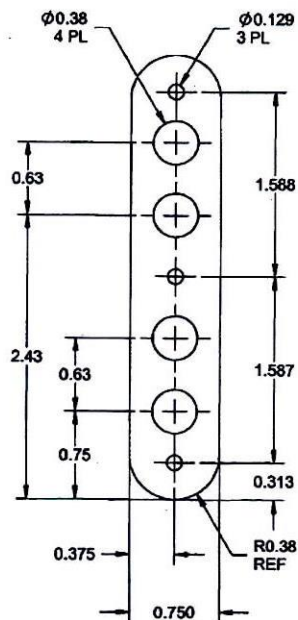
Revision:

Inspector:

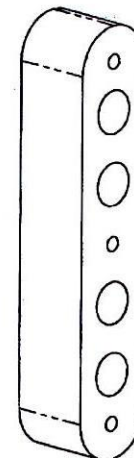
Date: 03/28/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	
2	Spacer	0.380Inches ± 0.030	0.410 0.350	Diameter	
3	Spacer	0.630Inches ± 0.030	0.660 0.600		
4	Spacer	1.588Inches ± 0.010	1.598 1.578		
5	Spacer	2.430Inches ± 0.030	2.460 2.400		
6	Spacer	0.630Inches ± 0.030	0.660 0.600		
7	Spacer	1.587Inches ± 0.010	1.597 1.577		
8	Spacer	0.750Inches ± 0.030	0.780 0.720		
9	Spacer	0.313Inches ± 0.010	0.323 0.303		
10	Spacer	0.380Inches ± 0.030	0.410 0.350	Radius	
11	Spacer	0.375Inches ± 0.010	0.385 0.365		
12	Spacer	0.750Inches ± 0.010	0.760 0.740		
13	Spacer	0.735Inches + 0.000 - 0.010	0.735 0.725		

Plex 2/20/18 11:36 AM dart.logan.david



D4149-3 SPACER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172545

20180220

RELEASED
2011-02-22

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C		
DRAWN	SC				
CHECKED				DRAWING NO.	SHEET 4 OF 5
MFG. APPR.				D4149	SCALE
APPROVED				TITLE	NTS
DE APPR.				AFT X-TUBE LUG ASSY	
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD			
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

